

Work Order ID 80056

80056

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February-09-12 12:45:23 PM

Item ID: D2654-1

Accept

N900040100

Setup: Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web

Start Date: 09/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M L J

Date: 12/02/09 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2654	F

100 Skidtubes 0.00

100

Skidtubes

Skidtubes

Memo

0.00

1-Cut D2600-5 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

120 Chemical Conversion Coat per QSI005 4.1 0.00

120

HandFinish

Hand Finishing

Memo

0.00

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Quality Control

Memo

0.00

12-03-28

(10) SAD 12-03-28

NP 12-13-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

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Revision ID:

Item Name: Web

Stop ***NS2***

Start Date: 09/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Identify as per dwg & Stock Location: *4/6*

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

DP 12-3-28
12/3/29
MF 12-03-29

Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 80056

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Parent Item: D2654-1

D2654-1

Parent Item Name: Web

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM
IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	227.0000	1	10			
D2600-5-108									**				
Extrusion 'I Beam' thin													

Location

Loc Qty

Loc Code

LG

227

47814

20

73909

207

10 12 03 27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

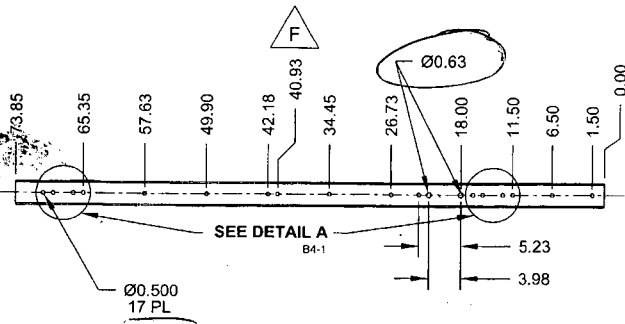
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

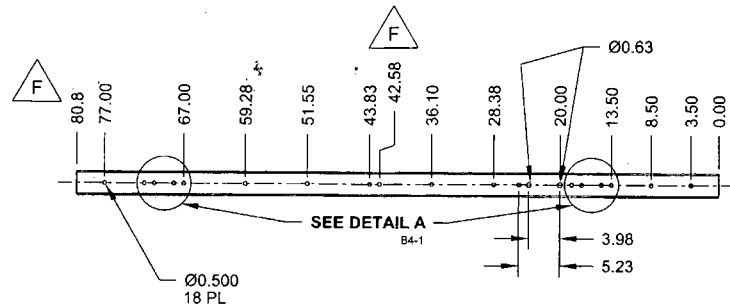
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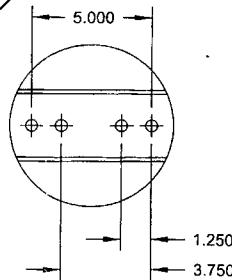
8 7 6 5 4 3 2 1



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D5-2
B3-2
B6-2

RELEASED
2011-09-12

80056 M.C.J
12/02/09

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHV HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	CP	D2654	SHEET 1 OF 2
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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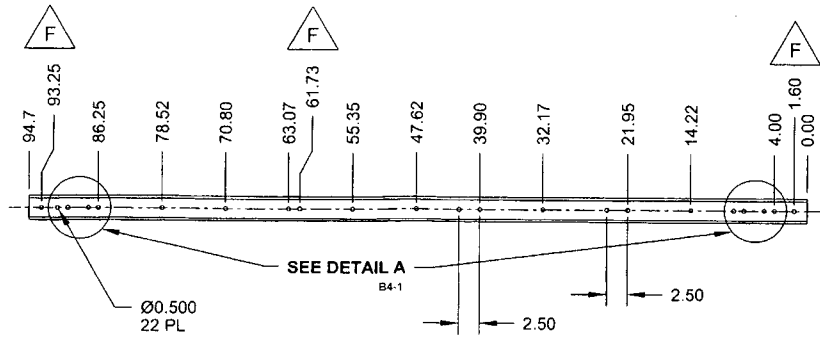
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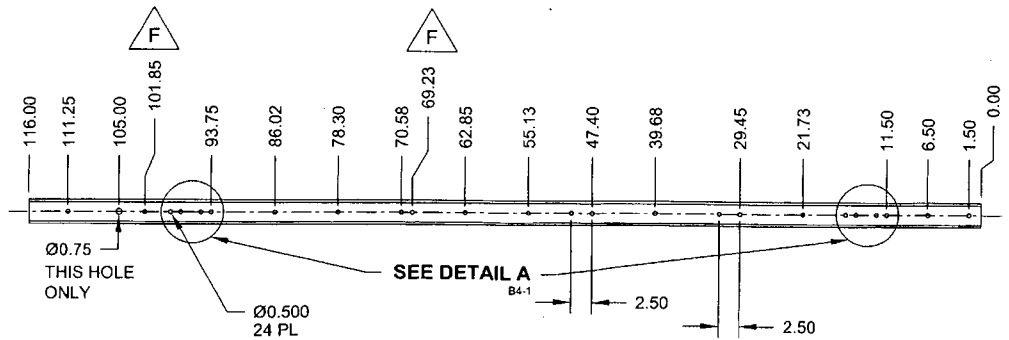
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D2654-5 WEB



D2654-7 WEB

RELEASED
2011-09-12
JW

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. F
MFG. APPR.	BE	D2654	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.		WEB	NTS
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